



Dart Aerospace Ltd.
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D2919-2**Job Sheet 202872****Part No:** D2919-2**Job Qty:** 4 pcs**Part Name:** Outer Saddle (Aft RH)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/5/19**Job Tracking No:****Due Date:** 12/23/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG D2919 REV.B IPP Rev. A 19.10.28 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	12/23/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/12/09
							HAAS - 4		
100	HAAS 4 Axis	4 pcs	12/23/19		2.00	7.50	HAAS - 1 - B4B	DAS	
							HAAS - 2 - B4B	23	
							HAAS - 3 - B4B	9-89	SBL 19/12/10
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	4 pcs	12/23/19		0.00	0.53	Conventional Mill - 1 - B4B	DAS	
							Conventional Mill - 2 - B4B	23 9-89	VAS 19/12/10
120	QC 2	4 pcs	12/23/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22	DAS	
							QC 2 - 23	23	VAS 19/12/10
							QC 2 - 25	9-89	
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		

**Container No:** S238103**Part:** D2919-2**Job No:** 202872**Serial No/Batch:** S238103**Revision:** B**Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 12/09/19

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	4 pcs	12/23/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Da 20-04-28
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	12/23/19	0.00 0.19	Handfinish - 1 - 1 - B4B	Da 20-04-30
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Plex 11/5/19 7:59 AM Dart.lajeunesse.marie	

					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
145 QC 3	4 pcs	12/23/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150 Powdercoat - 1 White GI(A)- B4B	4 pcs	12/23/19	0.00 0.17		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	20-05-1
					Powdercoat - 4 - B4B	
160 QC 3	4 pcs	12/23/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	20-05-20
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	20-05-01
					QC 3 - 68	
					QC 3 - 9	

DAS 34 9-89

DAS 34 9-89

DAS 59 9-89

				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	DAS
170 Packaging 3-1 - Stock - B4B	4	12/23/19	0.00 0.00	Packaging 3 - 1 - B4B	84
	pcs			Packaging 3 - 2 - B4B	9-89
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
180 QC 21 - FG	4	12/23/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	OCT 29 2020 70
				QC 21 - FG - 53	9-89
Part Op 100 - (HAAS CNC Vertical Machine) Program batch number Machine Step No 1 as per Folio F069 and visually inspect Descriptions: as per Dwg D2919 & attached Dimension Sheet Machine Step No 2 as per Folio F069 and visually inspect as per Dwg D2919 & attached Dimension Sheet Machine Step No 3 as per Folio F069 110 - (Manufacture as per dwg) Machine Keyway and inspect per Dwg D2919 & attached dimension sheet 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 145 - (QC3- Inspect Part Finish) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6102-010	Saddle Billet	4 pcs (1 ea)	90-Machining - Issue SN	5236 580	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Machining - Issue SN	D6102-010	4	0	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 202 872
Description: Outer Saddle		Part Number: D2919-2
Inspection Dwg: D2919 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.175	0.205		0.189	0.190	0.190	0.190	
B	1.510	1.525		1.520	1.510	1.510	1.510	
C	0.090	0.110		0.099	0.099	0.099	0.099	
D	0.250	0.270		0.260	0.262	0.262	0.262	
E	0.180	0.220		0.215	0.215	0.215	0.215	
F	1.762	1.782		1.780	1.781	1.781	1.781	
G	0.315	0.335		0.327	0.329	0.338	0.332	
H	3.495	3.535		3.520	3.520	3.520	3.520	
I	0.740	0.760		0.750	0.750	0.750	0.750	
J	0.225	0.255		0.240	0.240	0.240	0.242	
K	R0.178	R0.198		0.188	0.188	0.188	0.188	
L	4.436	4.446		4.441	4.441	4.441	4.441	
M	Ø0.256	Ø0.262		0.258	0.258	0.258	0.258	
N	1.225	1.235		1.232	1.232	1.232	1.232	
O	1.225	1.235		1.230	1.230	1.230	1.230	
P	1.103	1.113		1.108	1.108	1.108	1.108	
Q	1.278	1.288		1.282	1.282	1.282	1.282	
R	0.713	0.733		0.729	0.730	0.730	0.730	
S	1.498	1.508		1.503	1.503	1.503	1.503	
T	1.498	1.508		1.504	1.503	1.503	1.503	
U	R0.470	R0.530		0.500	0.500	0.500	0.500	
V	R1.990	R2.010		2.000	2.000	2.000	2.000	
W	0.755	0.765		0.760	0.760	0.760	0.760	
X	0.352	0.372		0.362	0.362	0.362	0.362	
Y	2.045	2.055		2.050	2.050	2.050	2.050	
Z	0.308	0.312		0.312	0.312	0.311	0.311	
AA	0.615	0.635		0.626	0.626	0.628	0.626	
AB	1.240	1.260		1.252	1.252	1.252	1.252	
AC	R0.053	R0.073		0.060	0.060	0.060	0.060	
AD	0.225	0.255		0.243	0.242	0.241	0.245	
AE	Ø0.437	Ø0.443		0.438	0.438	0.438	0.438	
AF	0.490	0.510			0.5025	0.502	0.504	
AG	1.745	1.755		1.750	1.750	1.750	1.750	
AH	3.495	3.505		3.500	3.500	3.500	3.500	
AI	1.745	1.755		1.750	1.750	1.750	1.750	
AJ	0.514	0.534		0.528	0.528	0.528	0.528	
AK	7.990	8.010		7.999	7.999	7.999	7.999	

Accept/Reject

NO

Measured by: SBC	Date: 19/12/10
Audited by: A.C.	Date: 20-04-28
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM	
B	08.04.21	Reformat	KJ/JLM	